

Work Order ID 73628

Wednesday, September 07, 2011 3:12:13 PM



Page 1

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 9/7/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: M114649 0.00



Large Fab

Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
2- Drill holes using DT9563 and chamfer holes as per dwg D4035
3- remove identification marks and deburr
4- Weld bushing in rib and grind weld flush as per dwg D4035

PC11.05409 6 cut MAB 11/07/12

110

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Memo

0.00

Quality Control

8 4/02/12

P1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73628

Wednesday, September 07, 2011 3:12:13 PM



Page 2

Item ID: D4035-043

Accept



Setup Start



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Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 9/7/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: W00A6

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Cpl / PNB ⑥ 11/09/12

*11/9/13 [Signature]
MK
11-09-12*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 3:12:11 PM

Page 1

Work Order ID: 73628

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 9/7/2011

Required Date: 9/13/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
IPP Rev:B as

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D4021-9

Manufactured

No

100

Each

112.0000

2

6



Bushing

PMB 11-9-12

Location

Loc Qty

Loc Code

WA

110

70333

46

72482

64

WA005

2

66437

2

M304TS0.750W.049

Purchased

No

100

f

301.2313

1.75

5.526316



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

200.4760839

117775

98.2133

118472

102.262784

MAT034

1.8507

117337

1.8507

WA

98.90454

118184

98.90454

Pl 11-09-09

~~3.5263~~ 11.0526

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

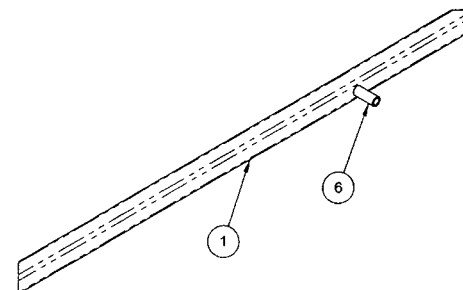
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

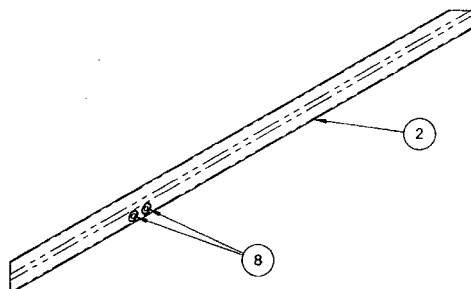
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

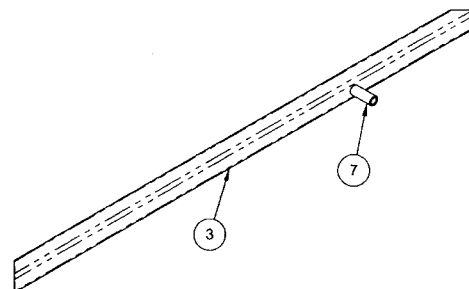
| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-----------|---------------------------|
| | X | | | | D4035-041 | LID RIB ASSY, FWD |
| | | X | | | D4035-043 | LID RIB ASSY, AFT |
| | | | X | | D4035-045 | LID RIB ASSY, FWD (LIGHT) |
| | | | | X | D4035-047 | LID RIB ASSY, AFT (LIGHT) |
| 1 | 1 | | | | D4035-1 | RIB |
| 2 | | 1 | | | D4035-3 | RIB |
| 3 | | | 1 | | D4035-5 | RIB |
| 4 | | | | 1 | D4035-7 | RIB |
| 5 | | | | 2 | D4035-11 | BUSHING |
| 6 | 1 | | | | D2327-3 | SPACER BUSHING |
| 7 | | | 1 | | D2953-175 | SPACER |
| 8 | | 2 | | | D4021-9 | BUSHING |



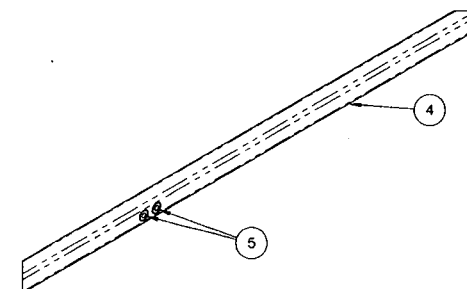
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

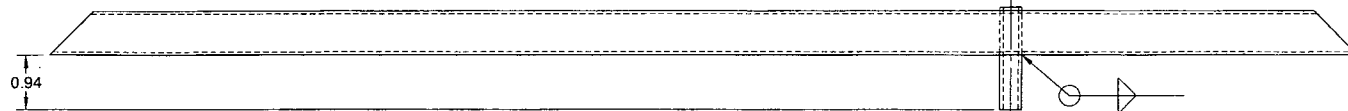


D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

W/D 73628

| | | | | | |
|------------|----------|--|---|--------|--------------|
| A | | NEW ISSUE | | JPH | 10.03.04 |
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4035 TITLE BASKET LID RIB ASSY | | REV. A | SHEET 1 OF 5 |
| DRAWN | JPH | | | SCALE | NTS |
| CHECKED | | | | | |
| MFG. APPR. | | | | | |
| APPROVED | | | | | |
| DE APPR. | | | | | |
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D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

73628

RELEASED
2010-03-12
WDO

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID RIB ASSY | NTS |
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

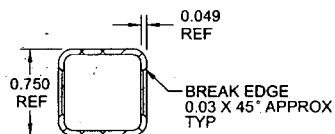
RELEASED
2010-03-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs
 - 8) WELDING: PER DART QSI 004

73628

| | | | |
|--|---------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. A |
| MFG. APPR. | AS | D4035 | SHEET 3 OF 5 |
| APPROVED | AS | TITLE | SCALE |
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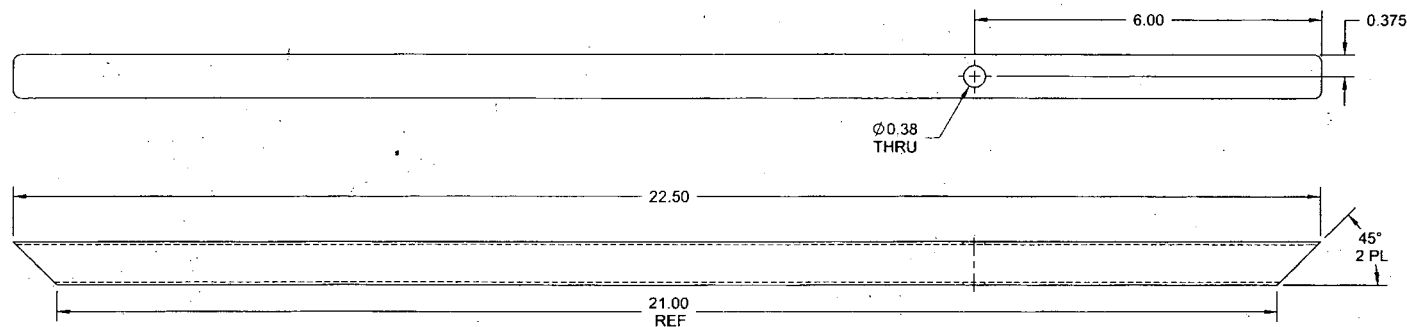
8 7 6 5 4 3 2 1



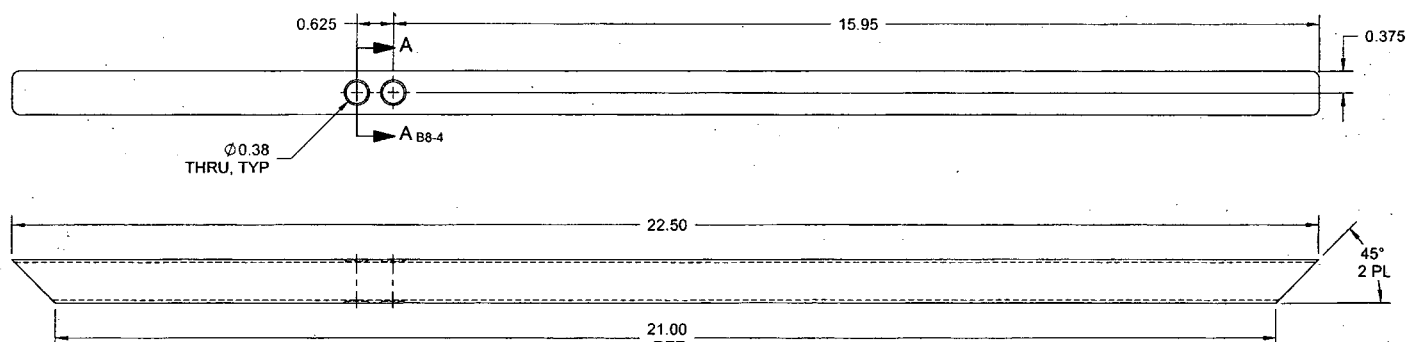
SECTION A-A B5-4

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 LBS



D4035-1 RIB

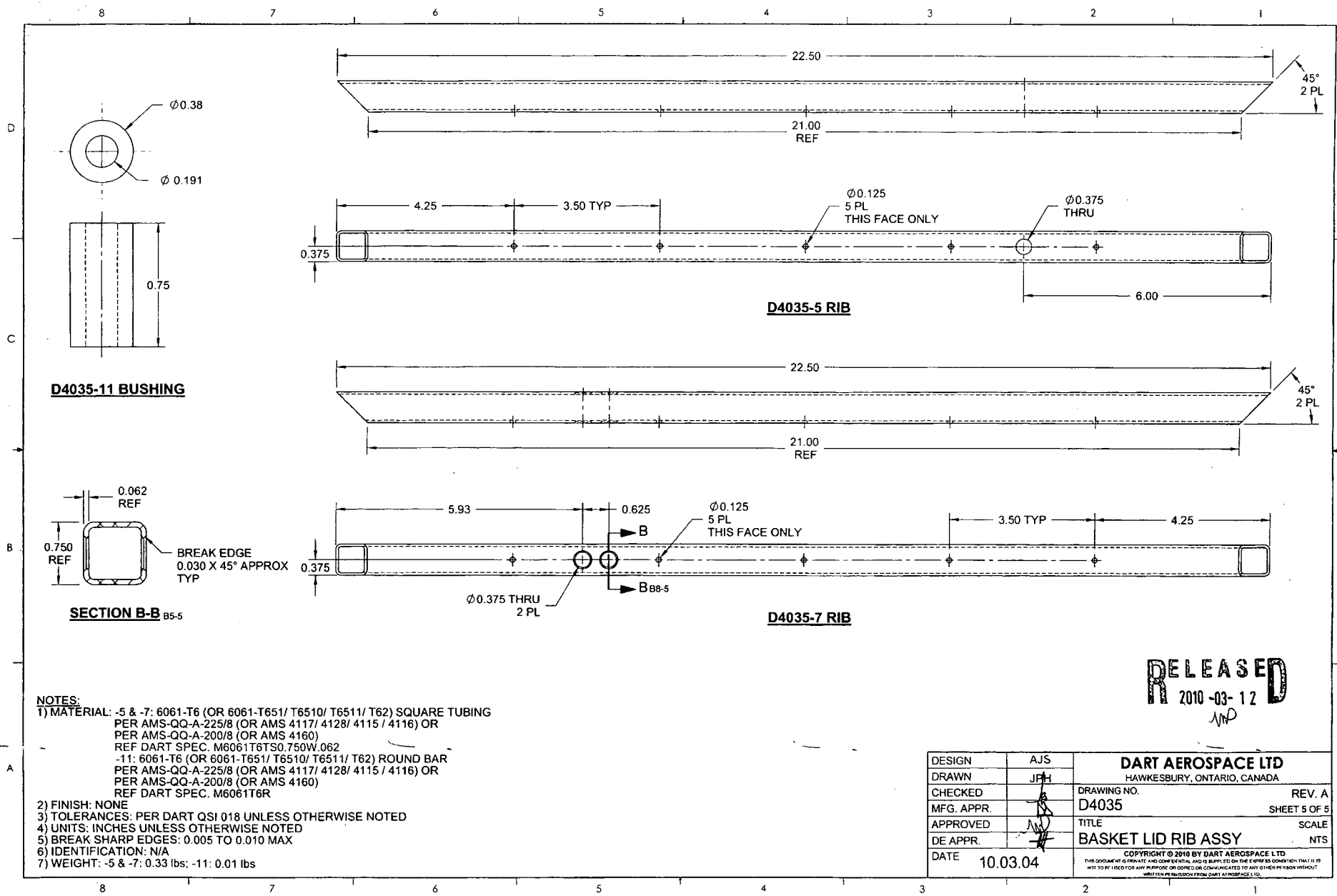


D4035-3 RIB

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2010-03-12
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|---|----------|--|--------------|
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| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID RIB ASSY | NTS |
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NOTES:

- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
 PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC. M6061T6TS0.750W.062
 -11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

RELEASED
 2010-03-12

| | | | |
|--|----------|--|--------------|
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| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4035 | SHEET 5 OF 5 |
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